



Nap-Gard®

7-0016

Green Internal Pipe Coating FBE

Revised: 7 October 2022

DESCRIPTION

Nap-Gard® 7-0016 internal pipe coating is a thermosetting epoxy powder generally used on the inside of steel pipe and fittings. When properly applied with the primer, Nap-Gard® 7-1808, Nap-Gard® 7-0016 will provide excellent corrosion protection even in high temperature, high pressure sweet and sour gas environments. However, performance may greatly be dependent on the service conditions. Therefore, it is the end user's responsibility to test this product to the specific service conditions before final application

TYPICAL POWDER PROPERTIES

Color:	Green	Theoretical Coverage:	132 Ft ² /lb/mil
Specific Gravity:	1.48 ± .05	Density: CSA Z245.20-22	1480 ± 50 g/L
Typical Gel Time: CSA Z245.20-22 @ 205°C (401°F)	50 ± 10 seconds	Shelf Life*: @ 25°C (77°F) @ 50% RH	6 months

* Transportation: The material is stable during transportation at temperatures below 25°C (77°F) and 50% RH.

TYPICAL PROPERTIES OF APPLIED FILM†

Recommended Film Thickness	Average Minimum	375µm (15 mils) 250µm (10 mils)
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Glass Transition Temperature T_{g3} (DMA)	Minimum 215°C (419°F)
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<u>TEST / REQUIREMENT</u>	<u>METHOD</u>	<u>CRITERIA</u>	<u>RESULT</u>
Bending	CSA Z245.20-22	1.0°/dia. Length @23°C	Pass
Hardness	ASTM D2583 ASTM D2240	Barcol Shore D	70 Average 90 Average
Taber Abrasion	ASTM D1044	CS – 17, 1 Kg 1000 Cycles	31 mg Loss
Pull Off Adhesion	ASTM D4541-09	Ramp Rate 100 psi/s	>5000 psi

† Performance depends on film thickness. Consult Nap-Gard® Specialist for specific recommendations.



AUTOCLAVE TESTING†

<u>50% Sour Gas Phase</u>	<u>Temperature</u>	<u>Pressure</u>	<u>Duration</u>	<u>Results</u>
5% H ₂ S 3% CO ₂ 92% CH ₄	149°C (300°F)	3000 psi	96 Hrs.	Pass all phases No blisters No swelling No adhesion loss No delamination
<u>50% Vol Aqueous Phase</u> Formation water				

†Performance depends on film thickness. Consult Nap-Gard® Specialist for specific recommendations

RECOMMENDATION APPLICATION PARAMETERS

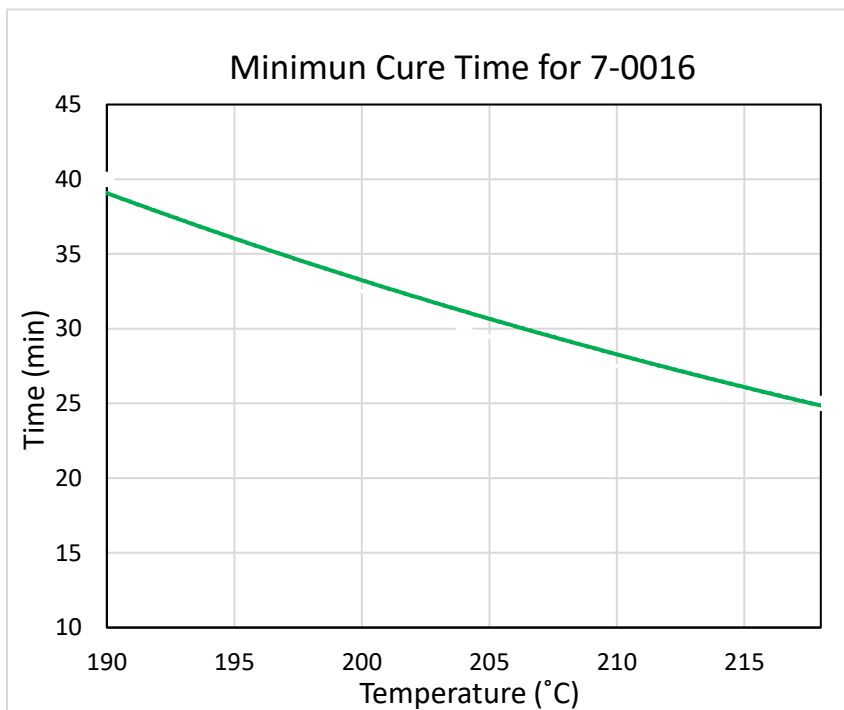
	NACE SSPC Swedish Standard	#1 White Metal SP-5 Sa 3
Surface Preparation		
Anchor Profile	Recommended Range Nominal	1.5 mils (38µm) - 3.5 mils (89µm) 2.5 mils (64µm) sharp, dense
Liquid Phenolic Primer Dry Film Thickness	Recommended Range	0.5 mils (13µm) - 1.0 mils (25µm)
Cured Powder Film Thickness	Recommended Range	10 mils (250µm) - 20 mils (500µm)
Preheat Temperature	Recommended Part Surface Temperature Range	375°F (191°C) - 425°F (218°C)
Cure Schedule	Follow Minimum Cure Time Chart Below	Minimum T _{g3} : 215°C (419°F) by DMA

† Performance depends on film thickness. Consult Nap-Gard® Specialist for specific recommendations.

Always consult product Material Safety Data Sheet (SDS) prior to handling.

WARRANTY POLICY: Axalta Powder Coating Systems USA, Inc. ("Seller") certifies that all coatings delivered to Customer in unopened factory filled containers meet all pertinent quality standards presented in Seller's current published literature. Since matters of surface preparation, application procedures, curing procedures and other local factors that affect coating performance are beyond Seller's control; Seller assumes no liability for coating failure other than to supply replacement material for coating material proven to be defective. Customer will determine suitability of this product for its use and thereby assumes all risks and liabilities in connection therewith. Seller will not be liable for any injuries, damages or other losses derived, directly or indirectly, from or as a consequence of Customer's use of the product. **SELLER DISCLAIMS ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, RELATING TO ITS PRODUCTS AND THEIR APPLICATION, INCLUDING BUT NOT LIMITED TO WARRANTIES OF MERCHANTABILITY AND FITNESS FOR PARTICULAR PURPOSES.**





TRANSPORTATION AND STORAGE

The material is stable during transportation and storage at temperatures below 25°C (77°F) and 50% RH.

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